

Work Order ID 140557

Friday, January 08, 2016 7:38:55 AM

140557

Page 1

Item ID: D4822-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Deflector, LH

Start Date: 1/7/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/7/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4822	C								

100

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT AT 32.00" LONG

1. length make 2 parts

0.00

DAS
13
9-89

JAN 13 2016

2

110

0.00

110

Outsource5

Outsource process - Machining

Memo

ISSUE P/O: 30870
POSSIBLE SUPPLIER: WEJAY

Certificate of conformaty required

0.00

DAS
13
9-89

JAN 13 2016

31

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Packaging

Memo

0.00

DAS
13
9-89

FEB 2 - 2016

3

Work Order ID 140557

Friday, January 08, 2016 7:38:55 AM

140557

Page 2

Item ID: D4822-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Deflector, LH

Start Date: 1/7/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/7/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

117

QC6- Inspect dimensions to drawing

0.00

117

QC

Memo

0.00

Quality Control

3

FEB 22 2016

DAS
38
9-89

120

0.00

120

Outsource4

Memo

0.00

Outsource process - Anodize

HARD ANODIZE IAW MIL-A-8625 TYPE 3
COLOUR BLACK

PRIME AS PER DWG NOTE #2

P/O: 31446

Received

3

FEB 23 2016

DAS
13
9-89

122

QC14- Inspect Spray Paint

0.00

122

QC

Memo

0.00

Quality Control

3

MAR 03 2016

DAS
38
9-89

3 + SP16-03-3

Work Order ID 140557

Friday, January 08, 2016 7:38:55 AM

140557

Page 3

Item ID: D4822-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Deflector, LH
Start Date: 1/7/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/7/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
140						3			
QC	Memo	0.00							
Quality Control									MAR 03 2016
170	Identify as per dwg & Stock Location: <u>Q1K042</u>	0.00							DAS 6 9-89
170						3			
Packaging	Memo	0.00							MAR 03 2016
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190						15			
QC	Memo	0.00							MAR 07 2016
Quality Control									

20160304

SA

Picklist Print

Friday, January 08, 2016 7:38:54 AM

Page 1

Work Order ID: 140557

140557

Parent Item: D4822-1

D4822-1

Parent Item Name: Upper Deflector, LH

Start Date: 1/7/2016

Required Date: 1/7/2016

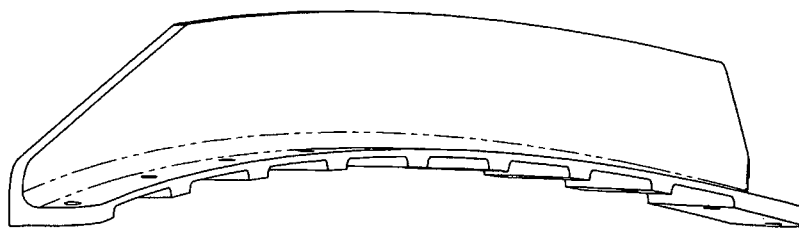
Start Qty: 4.00

Required Qty: 4.00

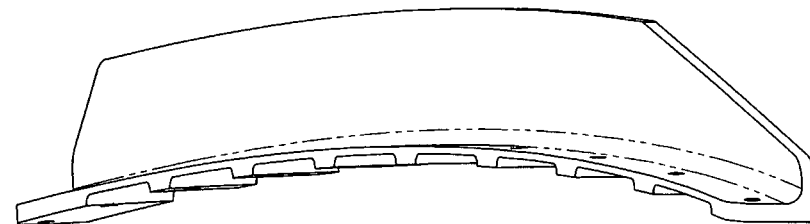
Comments: IPP REV:A NEW ISSUE 13-04-19 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4822-1P		Purchased	No				Each	0.0000		4		DAS 6 9-89	
D4822-1P									**				
Upper Deflector, RH													
M7075T6B4.000X4.000		Purchased	No				f	24.0004		11.36842		DAS 13 9-89	
M7075T6B4 000X4 000									**	5.68421		JAN 13 2016	
7075-T6 BAR 4.000" X 4.000"													
CUT AT 32" LONG													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT024				24.0004					
				m133930				24.0004					

3x M13930
~~8x M13930~~



D4822-1 UPPER DEFLECTOR LH



D4822-2 UPPER DEFLECTOR RH

STOCK COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ANY NOTIFICATION

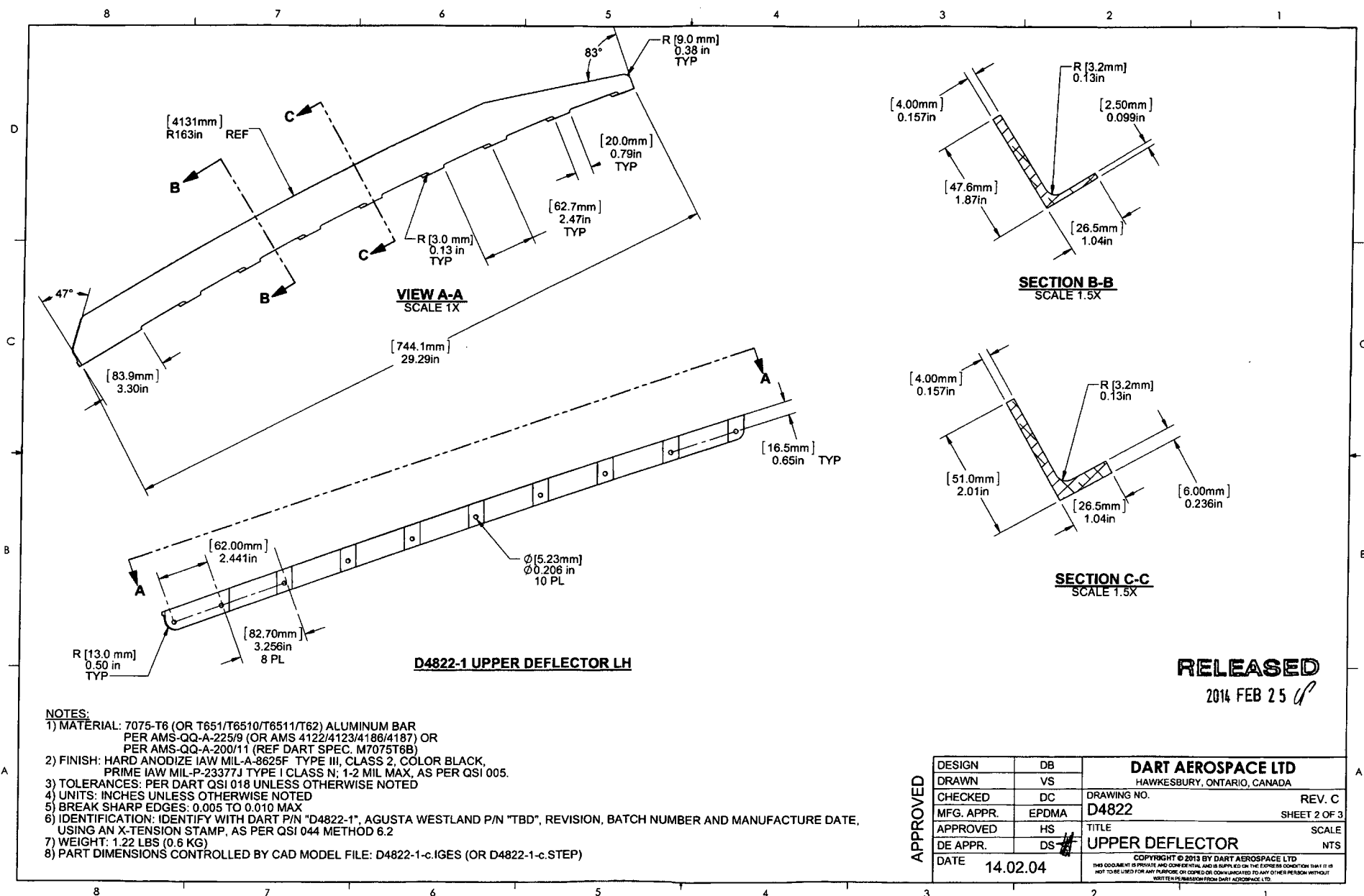
WITH THE
WIND TUNNEL
NO. 140557 MJS
16-01-07

RELEASED

2014 FEB 25
ECN 19-516

C	DRAWING REVISED TO NEW CUSTOMER CAD DATA, RIVET HOLES ADDED	DB	14.02.04
B	CORRECTED WEIGHT	DW	13.09.24
A	NEW RELEASE	DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	EPDMA	D4822	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	UPPER DEFLECTOR	NTS
DATE	14.02.04	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



RELEASED

2014 FEB 25



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace

DATE: Feb. 11, 2016

P.O.# PO30870

WEJAY JOB# 37749

I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.

PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4822-1P	8	Machined complete per drawing req'ts.	D4822 / rev. C
REDACTED			
D4822-2P 'Upper Right Hand Deflector' B140388	8	Machined complete per drawing req'ts.	D4822 / rev. C
D4822-1P 'Upper Left Hand Deflector' B140557	4	Machined complete per drawing req'ts.	D4822 / rev. C
D4822-2P 'Upper Right Hand Deflector' B140558	6	Machined complete per drawing req'ts.	D4822 / rev. C

Note: 1) Each part is tagged with 'Dart' Material Batch number.

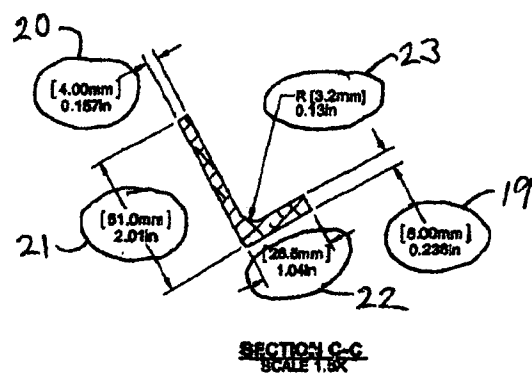
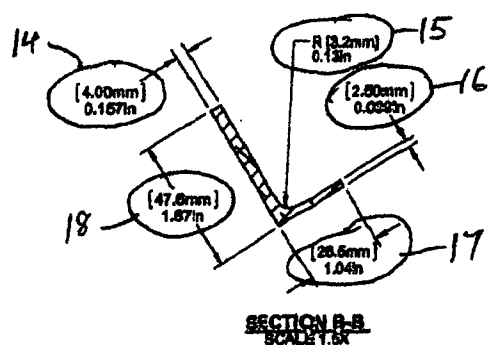
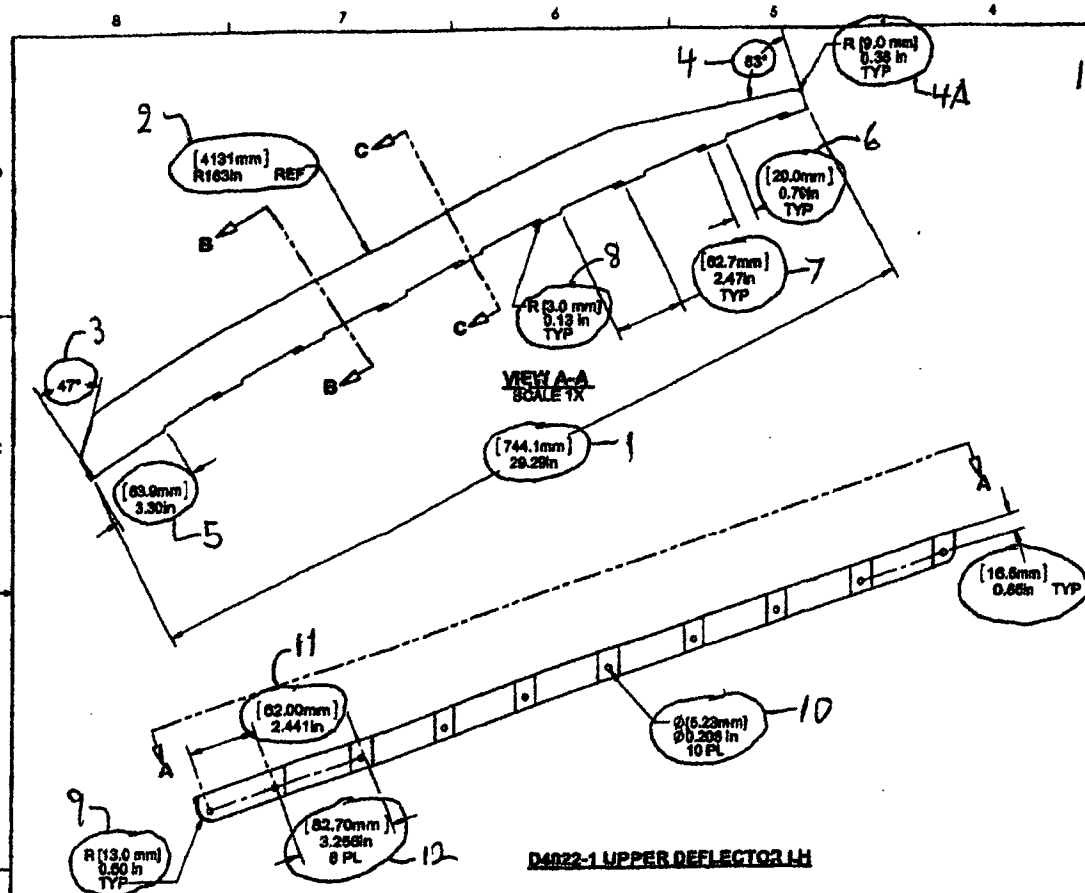
2) 1st Article Inspection reports attached.

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith

Authorized Q.A. Signatory



RELEASED
2014 FEB 25

NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/0 (OR AMS 4122/4123/4184/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC. M7075185)
- 2) FINISH: HARD ANODIZE IAW MIL-A-5520F TYPE II, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS N: 1-2 MIL. MAX. AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4822-1", AGUSTA WESTLAND P/N "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE,
USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 5.2
- 7) WEIGHT: 1.22 LBS (0.6 KG)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4822-1.c.IGES (OR D4822-1.c.STEP)

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	EPDMA	D4822	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS-11	UPPER DEFLECTOR	NTS
DATE	14.02.04	COPYRIGHT © 1975 BY DART AEROSPACE LTD	



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 37749

PAGE: 1 of 1

CUSTOMER: Dart Aerospace

CUST. P.O.# PO 30870

PART No. D4822-1

DESCRIPTION: Deflector Left Hand

DWG No. D4822

REV. C

E.C.O. --

MATERIAL:

INSPECTOR: *[Signature]*

QUANTITY
REC'D: 1

ACCEPT: 1

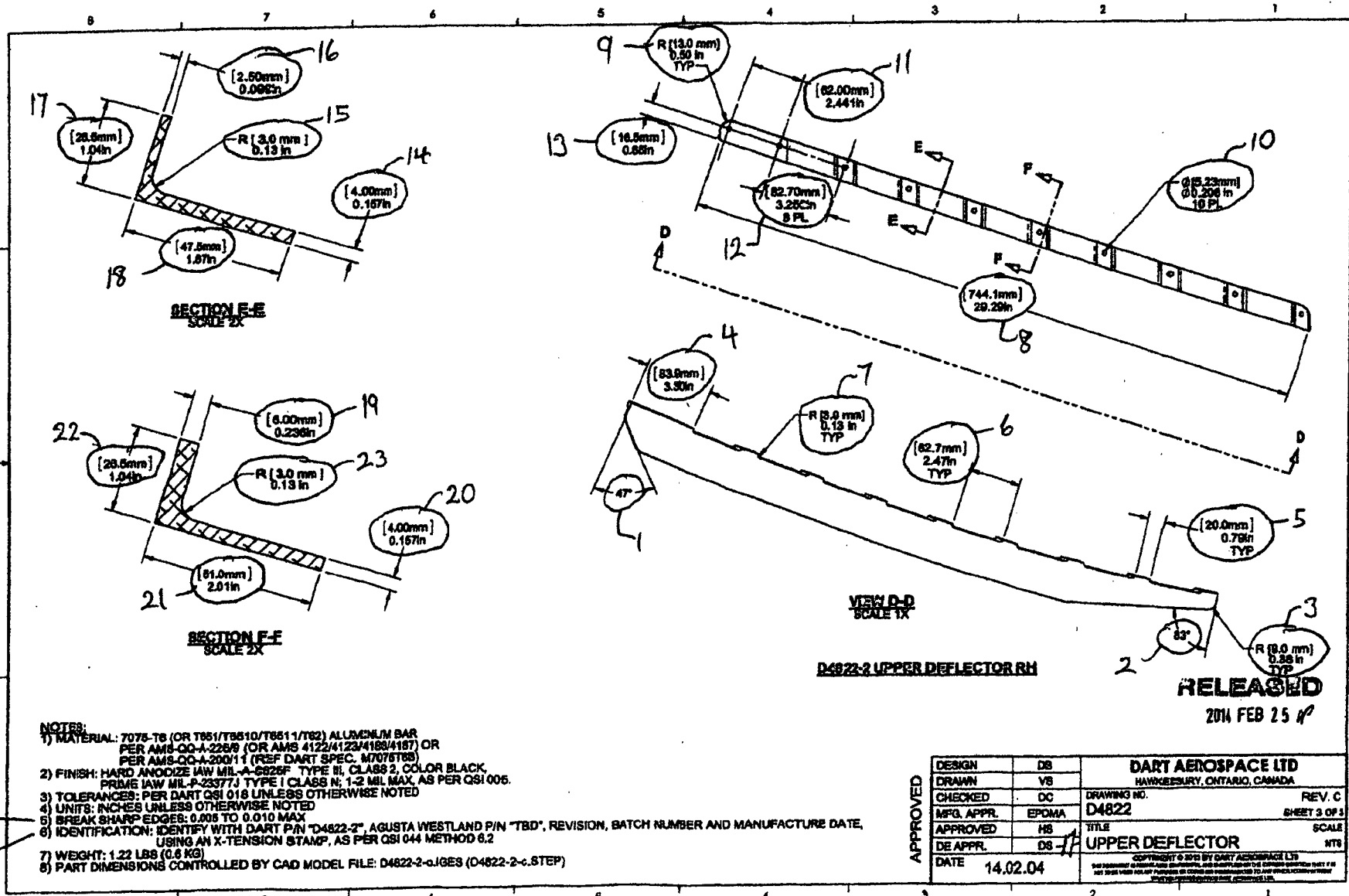
REJECT: —

N.C.R.# —

DATE: JAN 29/16

INSTRUCTIONS, COMMENTS: Standard Tolerances per DART QSI 018 unless otherwise noted
-First Article Inspection-

ITEM REF. No.	CHARACTERISTIC (DIMS IN mm)	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	29.29"	View A-A	±.03	2/C6	29.31	1	Acc-
2	R163" ref		±.10	2/D7	O.K.	1	"
3	47°		±.5°	2/C8	46.5°	1	"
4	83°		±.5°	2/D5	82.5°	1	"
4A	R 0.38" typ.		±.03	2/D4	R-38 TYP	1	"
5	3.30"		±.03	2/C8	3.311	1	"
6	0.79" typ.		±.03	2/D5	800/811	1	"
7	2.47		±.03	2/D5	2.455/2.470	1	"
8	R 0.13 typ.		±.03	2/C6	R-125 TYP	1	"
9	R0.50" typ		±.03	2/B8	R-500 TYP	1	"
10	Ø0.206 hole thru	10 pl.	+0.005/-0.001	2/B5	Ø.208 TYP	1	"
11	2.441"		±.010	2/B7	2.443	1	"
12	3.256" typ.	8 pl.	±.010	2/B7	3.255/3.258	1	"
13	0.65" typ.	10 pl.	±.03	2/B4	.643/.646	1	"
14	0.157"	Section B-B	±.01	2/D3	.158/.164	1	"
15	R0.13" typ.		±.03	2/D2	R-.19 TYP	1	"
16	.099"		±.01	2/D2	.099/.105	1	"
17	1.04"		±.03	2/D3	1.040/1.044	1	"
18	1.87"	Section C-C	±.03	2/D3	1.875/1.878	1	"
19	0.236"		±.01	2/B1	.236/.243	1	"
20	0.157"		±.01	2/C3	.158/.164	1	"
21	2.01"		±.03	2/B3	2.012/2.017	1	"
22	1.04"		±.03	2/B2	1.040/1.044	1	"
23	R0.13" → .197 R ON E-MODEL		±.10	2/C2	R-.187 TYP	1	"
24	Deburring	Per note 5	.005-.010	2/A8	O.K.	1	"
25	Identification	Per note 6		2/A8	N/A	1	"





600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No.

37749

PAGE: 1 of 1

CUSTOMER: Dart Aerospace

CUST. P.O.# PO 30870

PART No. D4822-2

DESCRIPTION: Deflector Right Hand

DWG No. D4822

REV. C

E.C.O. --

MATERIAL:

INSPECTOR:

QUANTITY
REC'D: 1

ACCEPT: 1

REJECT: -

N.C.R.# -

DATE:

JAN 29/14

INSTRUCTIONS, COMMENTS: Standard Tolerances per DART QSI 018 unless otherwise noted

ITEM REF. No.	CHARACTERISTIC (DIMS IN mm)	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	47°	View D-D	±.5°	3/B5	46.5°	1	Acc.
2	83°		±.5°	3/B2	82.5°	1	"
3	R 0.38" typ.		±.03	3/B1	R.38 TYP.	1	"
4	3.30"		±.03	3/C5	3.308	1	"
5	0.79" typ.		±.03	3/B1	.794/.805	1	"
6	2.47		±.03	3/B3	2.457/2.460	1	"
7	R 0.13 typ.		±.03	3/C4	R.125 TYP.	1	"
8	29.29"		±.03	3/C3	29.315	1	"
9	R0.50" typ		±.03	3/D5	R.500 TYP.	1	"
10	Ø0.206 hole thru	10 pl.	+0.005/-0.001	3/D1	.206 TYP.	1	"
11	2.441"		±.010	3/D4	2.442	1	"
12	3.256" typ.	8 pl.	±.010	3/D4	3.255/3.257	1	"
13	0.65" typ.	10 pl.	±.03	3/D5	.648/.652	1	"
14	0.157"	Section E-E	±.01	3/D6	.1595/.161	1	"
15	R0.13" typ. - .197" RADIUS E-MODEL		±.03	3/D7	R.190 TYP.	1	"
16	.099"		±.01	3/D7	.097/.107	1	"
17	1.04"		±.03	3/D8	1.045/1.046	1	"
18	1.87"	Section F-F	±.03	3/C7	1.869/1.874	1	"
19	0.236"		±.01	3/C7	.233/.244	1	"
20	0.157"		±.01	3/B6	.1595/.161	1	"
21	2.01"		±.03	3/B7	2.003/2.010	1	"
22	1.04"		±.03	3/B8	1.045/1.046	1	"
23	R0.13" - .197" RADIUS E-MODEL		±.10	3/B7	R.190 TYP.	1	"
24	Deburring	Per note 5	.005-.010	3/A8	O.K.	1	"
25	Identification	Per note 6		3/A8	N/A	1	"



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30870**

Purchase Order Date 1/5/2016

PO Print Date 1/13/2016

Page Number 2 of 3

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: **\$4,360.00**

5 D4822-2P

Upper Right Deflector

2/23/2016

6.00

\$1,090.00

\$6,540.00

Yes

Each

2/23/2016

MACHINE AS PER DWG D4822 REV. C
B140558

Line Total: **\$6,540.00**

6 71401-45

PROCUREMENT
QUALITY CLAUSES

2/23/2016

1.00

\$0.00

\$0.00

No

2/23/2016

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER,
(DOCUMENTATION MAINTAINED BY SUPPLIER)

A016 PERSONNEL QUALIFICATION

A024 PROCESS CERTIFICATIONS

A025 CERTIFICATE OF CONFORMANCE

A040 NOTIFICATION OF QUALITY ESCAPE

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENTS

PO Instructions: quotation no. WJ-8785

Note:

1/13/2016



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 37749

PAGE: 1 of 1

CUSTOMER: Dart Aerospace

CUST. P.O.# PD30870

PART No. D4822-2

DESCRIPTION: Deflector Right Hand

DWG No. D4822

REV. C

E.C.O. --

MATERIAL:

INSPECTOR: *[Signature]*

QUANTITY
REC'D: 1

ACCEPT: 1

REJECT: —

N.C.R.# —

DATE: FEB 5/16

INSTRUCTIONS, COMMENTS: Standard Tolerances per DART QSI 018 unless otherwise noted

ITEM REF. No.	CHARACTERISTIC (DIMS IN mm)	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	47°	View D-D	±.5°	3/B5	46.5°	1	Acc.
2	83°		±.5°	3/B2	82.5°	1	"
3	R 0.38" typ.		±.03	3/B1	R.38 TYP.	1	"
4	3.30"		±.03	3/C5	3.311	1	"
5	0.79" typ.		±.03	3/B1	.780 / .795	1	"
6	2.47		±.03	3/B3	2.460 / 2.477	1	"
7	R 0.13 typ.		±.03	3/C4	R.125 TYP.	1	"
8	29.29"		±.03	3/C3	29.3	1	"
9	R0.50" typ		±.03	3/D5	R.500 TYP.	1	"
10	Ø0.206 hole thru	10 pl.	+0.005 / -.001	3/D1	.208 Ø TYP.	1	"
11	2.441"		±.010	3/D4	2.444	1	"
12	3.256" typ.	8 pl.	±.010	3/D4	3.255 / 3.258	1	"
13	0.65" typ.	10 pl.	±.03	3/D5	.649 / .651	1	"
14	0.157"	Section E-E	±.01	3/D6	.159 / .161	1	"
15	R0.13" typ. → .197" RAD ONE MODEL		±.03	3/D7	R.190 TYP.	1	"
16	.099"		±.01	3/D7	.101 / .106	1	"
17	1.04"		±.03	3/D8	1.044 / 1.047	1	"
18	1.87"	Section F-F	±.03	3/C7	1.874 / 1.877		"
19	0.236"		±.01	3/C7	.238 / .243	1	"
20	0.157"		±.01	3/B6	.159 / .161	1	"
21	2.01"		±.03	3/B7	2.008 / 2.015	1	"
22	1.04"		±.03	3/B8	1.044 / 1.047	1	"
23	R0.13" → .197" RAD ONE MODEL		±.10	3/B7	R.190 TYP.	1	"
24	Deburring	Per note 5	.005-.010	3/A8	PASSED	1	"
25	Identification	Per note 6		3/A8	N/A	1	"



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31446

Purchase Order Date 2/23/2016

PO Print Date 2/23/2016

Page Number 4 of 6

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

140557

D4822-1 UPPER
DEFLECTOR REV. C

3/4/2016

Yes

3/4/2016

3.00

\$33.85

\$101.54

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total:

\$101.54

10 140388

D4822-2 UPPER
DEFLECTOR REV. C

3/4/2016

Yes

3/4/2016

9.00

\$31.28

\$281.54

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total:

\$281.54

11 140558

D4822-2 UPPER
DEFLECTOR REV. C

3/4/2016

Yes

3/4/2016

6.00

\$31.92

\$191.54

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total:

\$191.54

PO Instructions: admin fee included in unit price.

Note:

2/23/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 911339

Date: 03-Mar-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
5 ea	Part: 141920 647.1718 GUSSET Job: 19207	Rev: D PO: PO31446	Line: 3
3 ea	Part: 140557 D4822-1 UPPER DEFLECTOR Job: 19213	Rev: C PO: PO31446	Line: 9
DATE: <u>3/3/16</u>			
CERTIFIED SIGNATURE: <u>[Signature]</u>			
RECEIVER SIGNATURE: _____			
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
CERTIFICATE OF CONFORMANCE			
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.			
MADE IN CANADA.			